

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.15**SOURCE INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** SIR-000028**Date Inspected:** 06-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Quality Control Contact:** Lu Jian Hua**Quality Control Present:** Yes No**Material transfer:** Yes No N/A**Sampled Items:** Yes No N/A**Stock Transfer:** Yes No N/A**OK to Cut:** Yes No N/A**Rebar Test Witness:** Yes No N/A**Delayed/Cancelled:** Yes No N/A**Other:** NA**Bridge No:** 34-0006**Component:** NA**Bid Item:** 52 & 55**Lot No:** NA**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe quality control functions related to welding, testing and fabrication procedures at the ZPMC facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The Caltrans Quality Assurance (QA) Inspector performed welder qualification radiograph film observations of the following radiographs that were welded with submerged arc welding (SAW), flux cored arc welding (FCAW) and shield metal arc welding (SMAW) processes. The reviewed radiographs are identified as follows:

SAW- #070403001, #070403002, #070403003, #070403004, #070403005, #070403006, #070403007.

FCAW- #070403101, #070403102, #070403104, #070403108, #070403109, #070403110, #070403111, #070403112, #070403120, #070403121.

SMAW- #070403058, #070403060, #070403061, #070403062, #070403064, #070403065, #070403067, #070403069, #070403052, #070403075, #070403077.

The radiographs were observed for radiographic procedure, film quality and film interpretation in accordance with AWS D1.5-2002 Section 5, Section 6 and Special Provisions requirement. The Caltrans QA observed five radiographs identified as 070403102, 070403058, 070403060, 070403005 and 070403007 that were unacceptable in accordance with contract documents. For film density, film interpretation acceptance (paragraph 5.27.3) and weld reinforcement removal (paragraph 5.26.1.1). The Caltrans QA inspector informed Mr. John Kinsey of the radiograph film review results. Mr. Kinsey stated that Caltrans would meet with American Bridge/Fluor (ABF) and ZPMC to clarify Caltrans project requirements.

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## SOURCE INSPECTION REPORT

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### Summary of Conversations:

Caltrans QA informed ZPMC QA Inspector, Mr. Lu of the discrepancies with the radiographs. Mr. Lu stated that ZPMC would release the welder qualification test plates for removal of the mechanical test specimens.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary, David	QA Reviewer

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